Nason® Industrial
NI 690 ISF 2K Topcoat

Product Description
2K isocyanate-free (ISF) acrylic topcoat based on amine-epoxy functional acrylic polymers.

Gloss
high

Colour
Distributor colour mix.

Simply swap the binder in any NI610/620 PU colour formula 1:1 with the NI690 ISF binder to generate the colour mix, then follow the “Application’ section below for activation and reduction.

Product Features
- Isocyanate free product
- Good resistance to sunlight exposure
- Tough finish
- Fast drying

Product Benefits
Can be applied in situ
Longer exterior service life
Hard wearing coating
Early handling

Suitable for interior and exterior applications.

Product Uses / Applications
- Shopping complexes and sporting arenas
- Handrails
- General steelwork, where aesthetic appearance is required
- Implements, agricultural and farm machinery
- Trucks, forklifts, tankers, tank exteriors
- Industrial and mining equipment
- Chemical plants, electrical generating equipment
- Concrete walls.
- Theme Parks
- Rail wagons and bogeys

Not Recommended for
Application over QD Enamel or thermoplastic paintwork.

Physical Data

Volume Solids (mixed):	Approx. 66.3% (white); 58.5% (black)
VOC:	492 g/L (mixed)
Specific Gravity (mixed):	1.03 – 1.21 g/mL
Dry Film Thickness:	50 - 75 microns
Theoretical Coverage (at 50 microns DFT):	8.9 m^2/L (white); 9.9 m^2/L (black)
Flash Point:	24°C

Dry Time

Air Dry at 20°C & 50% RH at recommended film thickness:
Dust Dry: 90 minutes Dry to Handle: 4 - 8 hours
Hard Dry: 24 – 30 hours

Bake: 35 minutes @ 60°C after 20 minutes flash-off @ 20°C.

Surface Preparation

Previously pained surfaces:
Clean using Axalta wax and grease remover.
Lightly sand with Audurra P320-400 or scour with 3M Scotch Brite Pad grey, and subsequently re-clean all the areas before the application of Nason® Industrial ISF 2K Topcoat.
Test suitability of the existing coating before application of Nason® Industrial ISF 2K Topcoat.

New work:
To be applied as a finish coat over an Axalta recommended primer e.g. 650-04 Nason® Industrial 2K ZP Epoxy Primer, 617-63 2K AM Epoxy Primer, Corlar 2.1 ST and the 309-03 Nason Industrial 2K P/U Primer White. Use over Axalta recommended Etch primers is allowed.

Wipe the area with Sontara® Tack Rag immediately prior application of Nason® Industrial ISF 2K Topcoat.

Application

- Mixing Ratio: 2:1 with Nason® Industrial ISF 2K Hardener
  Reducer: 15-20% Imron® FleetLine THP710/THP711 Thinner or Nason® Industrial ST300-501/502 or 861-62 Nason® Industrial Reducer.
- Pot Life: 5-6 hours @ 20°C

Gun Setup

• Pressure Pot (recommended):	1.2 – 1.3 mm	2.5 -3 bar	45 – 60 psi
• Conventional:	1.3 – 1.4 mm	2.5 - 3 bar	45 – 60 psi
• Airless Spray:	0.23 – 0.28 mm	min. 1500 psi	
• HVLP:	1.3 – 1.4 mm	0.7 bar	10 psi

Refer to spray equipment documentation for setting recommendations.

- Number of Coats: 2
- Flash-off Between Coats 5 minutes

Application Conditions

Do not apply if material, substrate or ambient temperature is less than 10°C or above 45°C. The substrate must be least 3°C above the dew point. Relative humidity should be below 90%.

Cleanup Solvents

Recommended Axalta gun cleaning thinner.

Dry Film Characteristics

Exterior Exposure:	GOOD
Maximum Service Temperature:	90°C (continuous service)
Humidity Resistance:	GOOD
Oil and Petrol Resistance:	GOOD

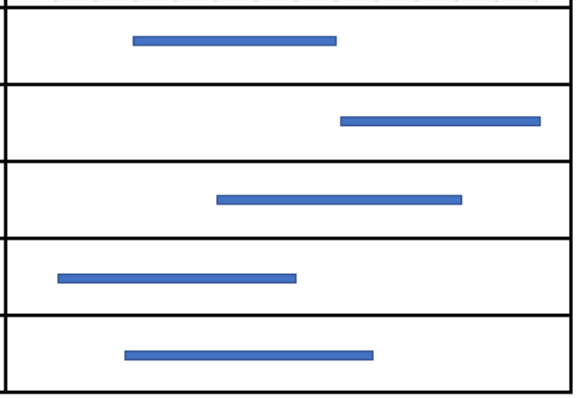
Recoating

Thoroughly scuff the surface with Audurra P320-400 or 3M Scotch Brite Pad grey.
Recoat with 1 – 2 coats of Nason® Industrial ISF 2K Topcoat, as necessary.

Shelf Life

24 months minimum in sealed original container.
Store at room temperature away from direct sunlight.

Table 1 – Reducer Selection Guide

Ambient Temperature			10°C 15°C 20°C 25°C 30°C 35°C 40°C
Nason® Industrial ST100-690 ISF 2K Topcoat	Air Dry or Bake (35 min @ 60C)	ST300-502 (Standard)	
		ST300-501 (Slow)	
		861-62 Nason® Industrial Epoxy Reducer	
		THP710 Imron® Fleetline Thinner	
		THP711 Imron® Fleetline Thinner	

Availability

Nason® Industrial ISF 2K Topcoat	10 L	ST100-690
Nason® Industrial ISF 2K Activator	5 L	ST200-547
Imron® Fleet® Line Thinner	5 L	THP710/THP711
Nason® Industrial Epoxy Reducer	20 L	861-62
Nason® Industrial Epoxy Reducer	4 L	861-62
Nason® Industrial ST501 Thinner Slow	20 L	ST300-501
Nason® Industrial ST501 Thinner Slow	5 L	ST300-501
Nason® Industrial ST502 Thinner Standard	20 L	ST300-502
Nason® Industrial ST502 Thinner Standard	5 L	ST300-502
Nason® Industrial Tints		ST-XX

This product is intended for use by professional trade and industrial applicators in compliance with relevant Health, Safety & Environmental standards and legislation.
The applicator must use suitable Personal Protective Equipment (PPE), in particular full body coverall, gloves, goggles and air respirator. Provide adequate ventilation when using in confined spaces
This Technical Data Sheet is issued by Axalta Coatings Systems as a guidance only. The information contained herein is current and correct to the best of our knowledge at the time of issuance.
The user must ensure suitability of the product and its performance for the application at hand. Axalta Coating Systems assumes no responsibility nor provides any warranty.